

Work Order ID 151521

Tuesday, September 27, 2016 11:55:05 AM

151521

Page 1

Item ID: D130-700-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: EC130 Bearpaws

Start Date: 9/20/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/30/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

DAS**21**

Date:

SEP 28 2016

Tooling:

Date:

QC:

9-89

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3167

Rev A1

OCT 18 2016

100

Document Control

0.00

DAS
6
9-89***100***

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D130-700-011CHG001

2**DAS**
28
9-89**OCT 27 2016**

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

2**DAS**
6
9-89**OCT 19 2016****DAS**
27
9-89

170

QC4- 100% Inspect kits for completeness

0.00

170

QC

Memo

0.01

Quality Control

2**DAS**
28
9-89**OCT 27 2016**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : _____					

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Item Name: EC130 Bearpaws

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Cust Item ID:

Required Date: 9/30/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Packaging	0.00							
180									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D130-700-011								
	LOCATION: FG012								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.03							
Quality Control									

2

DAS
2827
9-89g-89

OCT 27 2016

DAS
21
9-89

OCT 27 2016

DAS
21
9-89

OCT 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Tuesday, September 27, 2016 11:55:04 AM

Page 1

Work Order ID: 151521

151521

Parent Item: D130-700-011

D130-700-011

Parent Item Name: EC130 Bearpaws

Start Date: 9/20/2016

Required Date: 9/30/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-12A		Purchased	No			170	Each	189.0000	4	8			
AN4-12A									**			OCT 19 2016	
Bolt													

Location	Loc Qty	Loc Code
----------	---------	----------

FG	10	
120423	10	
over003	125	
m135704	125	
ST344	54	
m134606	54	

AN4-15A		Purchased	No			170	Each	105.0000	8	16			
AN4-15A									**			OCT 19 2016	
Bolt													

Location	Loc Qty	Loc Code
----------	---------	----------

GA	26	
120449	26	
ST343	79	
m134055	24	
m135127	1	
m135470	54	

D2182B060		Manufactured	No			170	Each	39.0000	4	8			
D2182B060									**			OCT 19 2016	
Clamp Cushion Black 6.0 "Long													

Location	Loc Qty	Loc Code
----------	---------	----------

FG	15	
93429	15	
ST639	24	
146738	24	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Tuesday, September 27, 2016 11:55:04 AM

Page 2

Work Order ID: 151521

151521

Parent Item: D130-700-011

D130-700-011

Parent Item Name: EC130 Bearpaws

Start Date: 9/20/2016

Required Date: 9/30/2016

Start Qty: 2.00

Required Qty: 2.00

D2274

Manufactured No

170

Each

29.0000

12 24

D2274

Radius Block

** 100353

OCT 19 2016

DAS 27 6 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

FG

12

86855

12

ST006

11

144391

11

ST012a

6

147530

6

D2519

Manufactured No

170

Each

0.0000

4 8

D2519

Clamp

** 150142

OCT 19 2016

DAS 27 6 9-89

D2529

Manufactured No

170

Each

0.0000

12 24

D2529

Washer

** 150996

OCT 19 2016

DAS 27 6 9-89

D3167-1

Manufactured No

Each

0.0000

4

D3167-1

Bearpaw

** 151496

OCT 25 2016

DAS 27 6 9-89

D3171-1

Manufactured No

170

Each

24.0000

4 8

D3171-1

Angle Bracket

** 151496

OCT 19 2016

DAS 27 6 9-89

Location

Loc Qty

Loc Code

ST019

24

143608

24

8

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Picklist Print

Tuesday, September 27, 2016 11:55:04 AM

Page 3

Work Order ID: 151521

151521

Parent Item: D130-700-011

D130-700-011

Parent Item Name: EC130 Bearpaws

Start Date: 9/20/2016

Required Date: 9/30/2016

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

170

Each

1,899.000

12

24

MS21042L4

Nut

**

OCT 19 2016

DAS
6 27
9-89 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

34

m133363

34

GA

404

m133769

104

m135058

300

OVER007

976

m135603

476

m135704

500

ST303

485

m135470

485

24

NAS1149D0463J

Purchased

No

170

Each

3,750.000

12

24

NAS1149D0463J

Washer

**

OCT 19 2016

DAS
6 27
9-89 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

230

M132035

15

M134508

32

M135056

183

ST260a

3000

M135530

1000

M135671

1000

M135767

1000

ST263

520

M135390

15

M135407

505

24

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : _____					



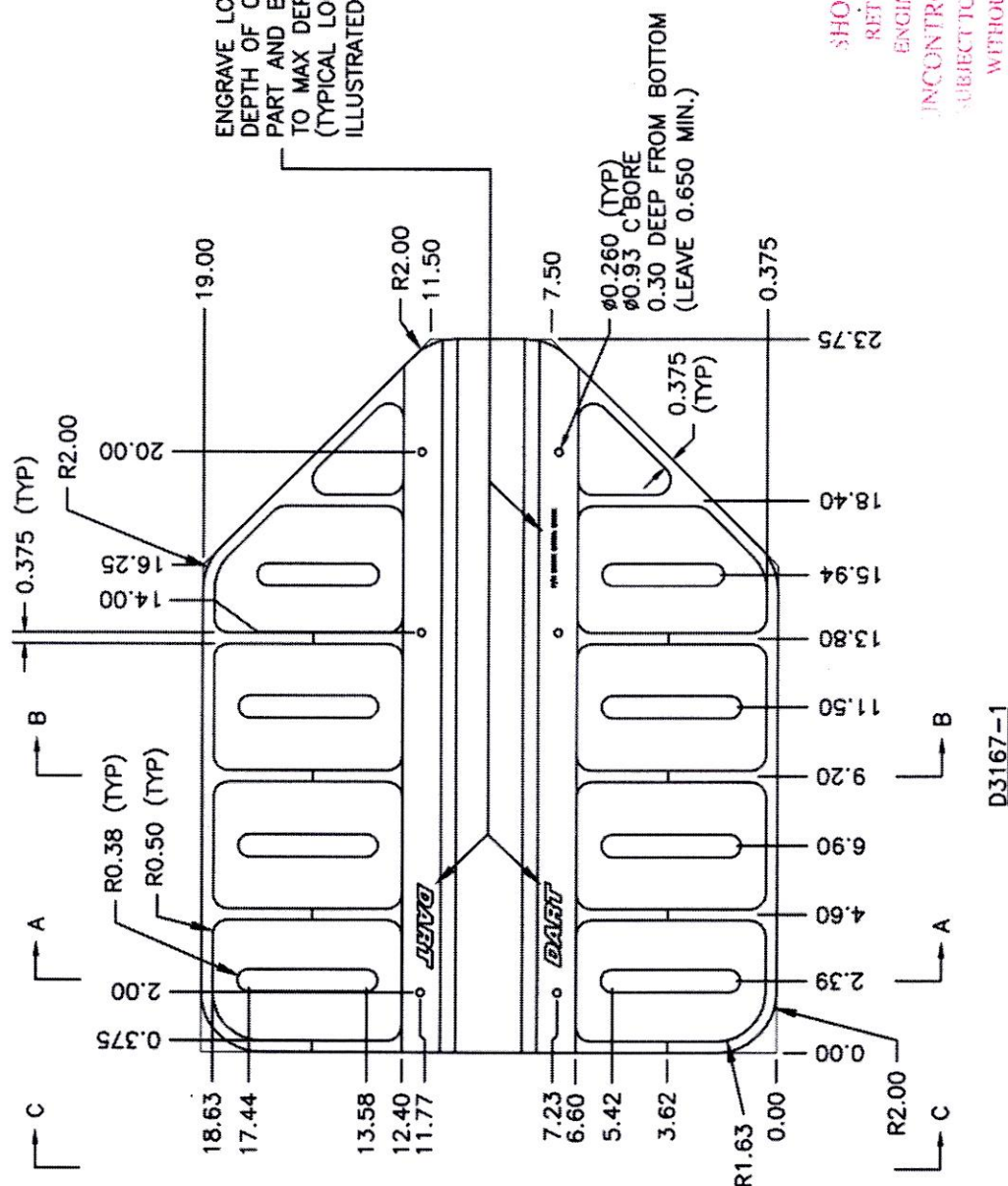
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CHECKED 	APPROVED 	DRAWING NO. D3167	REV. A SHEET 1 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:6
A	02.10.08	NEW ISSUE	
AI	02.12.17	5.80 WAS 5.50 	

RELEASED
02-10-25

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

157521 MC 87-6091



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

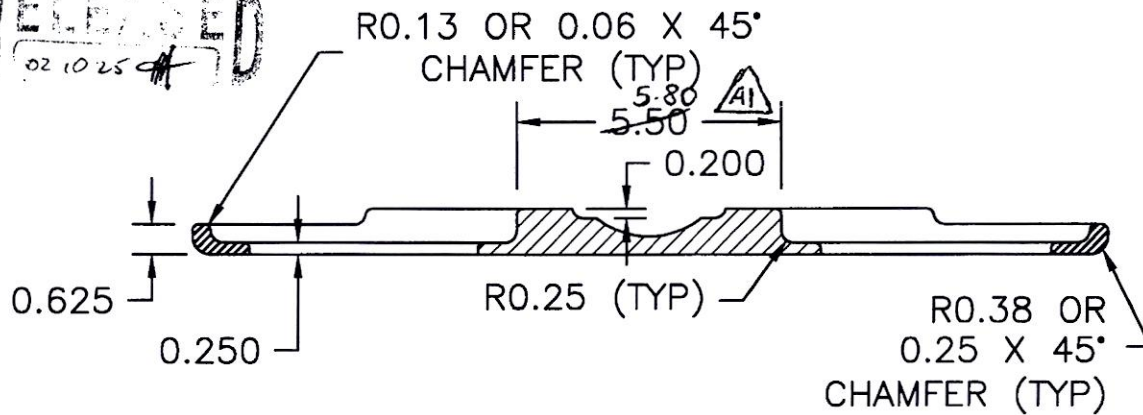
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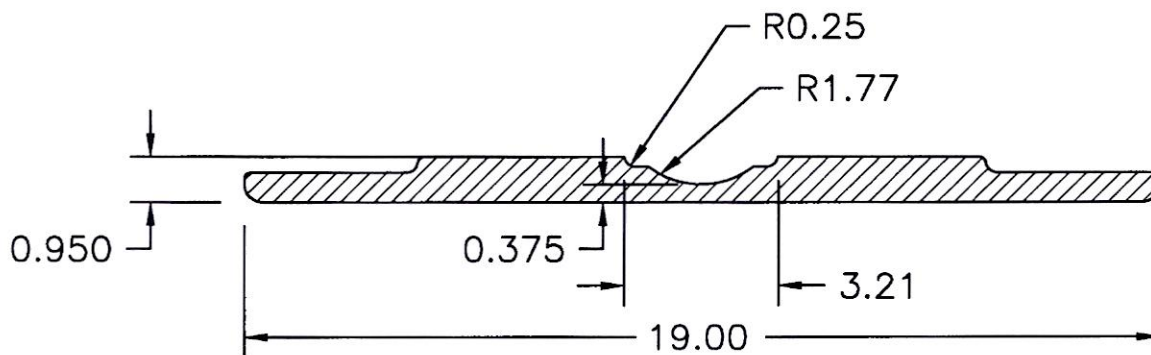


DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3167	REV. A SHEET 2 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:4

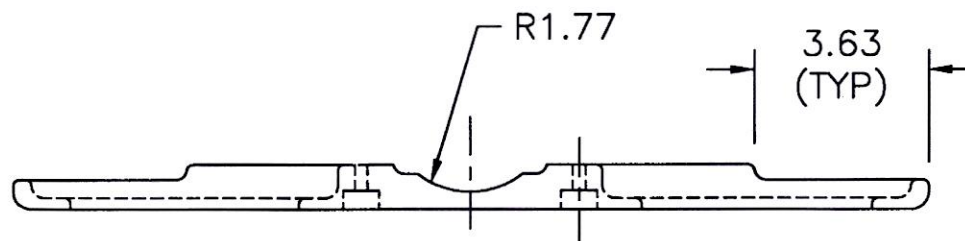
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02 10 25



SECTION A-A



SECTION B-B



SECTION C-C

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REFERENCE ONLYDAS
28
9-89**5 PARTS LIST**

Qty -011	Qty -021	Part Number	Description
X		D130-700-011	BEARPAW INSTALLATION
	X	D130-700-021	WEARPLATE KIT
4		D2182B060	Rubber Cushion
12		D2274	Radius Block
12		D2529	Washer
4		D2519	Clamp
2		D3167-1	Bearpaw
4		D3171-1	Angle
	2	D3862-041	Wearplate
4	4	AN4-12A	Bolt
8	8	AN4-15A	Bolt
12	12	NAS1149D0463J	Washer
12	12	MS21042L4	Nut (or MS21042-4)

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Revision: **B**

Date: 14.12.02

Wednesday, October 19, 2016 7:29:10 AM

Page 1

Quality Control